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Stocking Distributor

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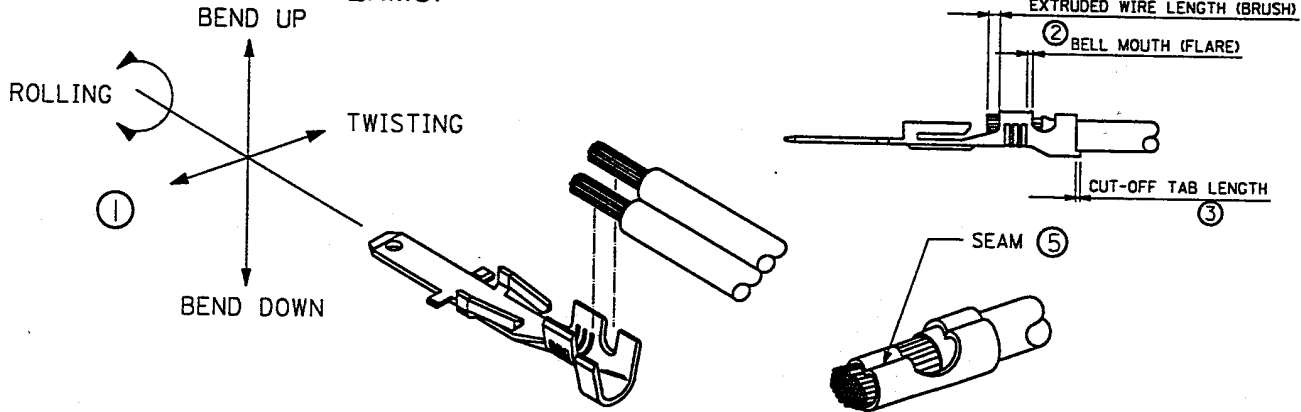
APPLICATION TOOLING TERMINATOR SPECIFICATION SHEET

A. SCOPE

THIS STANDARD SPECIFIES THE DIMENSIONS AFTER CRIMPING OF THE TERMINALS UNDERMENTIONED.

TERMINAL SERIES	WIRE SIZE	INSULATION DIAMETER		STRIP LENGTH	
		AWG	ENGLISH	(METRIC)	ENGLISH
43178-2001	14-18	.119 - .180	(3.02 - 4.57)	.156 - .218	(3.96 - 5.54)
43178-2001	18-DBL	.119 - .180	(3.02 - 4.57)	.156 - .218	(3.96 - 5.54)
-	-	-	(-)	-	(-)
-	-	-	(-)	-	(-)

B. DEFINITION (TERMS)



(2) 18 awg DBL WIRES
 POSITION WIRES AT 45°
 FROM ONE ANOTHER AS SHOWN
 OR ON TOP OF EACH OTHER
 DO NOT POSITION SIDE BY SIDE

INSULATION GRIP

CONDUCTOR GRIP

CORRECT POSITION

CORRECT POSITION

WRONG POSITION

NOTE:

*) IF THE CORRECT POSITION IS USED THEN YOU SHOULD NOT GET ANY WIRE STRANDS OUT OF THE CONDUCTOR CRIMP AREA.

*) IF THE WRONG POSITION IS USED THEN YOU ARE AT RISK OF STRANDS OF WIRE OUT OF THE CONDUCTOR CRIMP AREA.

DD-MMM-YYYY
 HHHMM
 Release Act
 ECD #138506
 MFS 12/04/96
 USER NAME

WORK AREA

REVISIONS

MFG. SH. RE. LTR.

DIMENSIONS SHOWN (METRIC) INCH

UNLESS OTHERWISE SPECIFIED
 TOLERANCES: ANGULAR ± 1/2°

	INCH	METRIC
3 PLACE	---	---
2 PLACE	---	± ---
1 PLACE	---	± ---

DRAFT WHERE APPLICABLE MUST
 REMAIN WITHIN DIMENSIONS

▽ = ▽ = REVISE ONLY ON CAD SYSTEM

TITLE
 Specification Sheet
 Terminator

Molex MOLEX INCORPORATED SHEET NO. DATE
 LISLE, ILL. 60532 U.S.A. 1 OF 4 96/03/06

PART NO. DRWG. NO.
 638406300 638406300

FILE NAME DIV. SIZE
 6384063 S80 THIS DRAWING CONTAINS INFORMATION THAT IS PROPRIETARY TO MOLEX INC. AND SHOULD NOT BE USED WITHOUT WRITTEN PERMISSION. AT A

CRIMP

C. SPECIFICATION

NO. OF FIG.	ITEM	REQUIREMENT
1	BEND UP	3°
	BEND DOWN	3°
	TWISTING	4°
	ROLLING	8°
2	BELL MOUTH (FLARE)	0.10-0.40
3	CUT-OFF TAB LENGTH	0.5 MAX.
4	EXTRUDED WIRE LENGTH (BRUSH)	1.50 MAX
5	SEAM	SEAM SHALL NOT BE OPENED AND NO WIRE ALLOWED OUT OF THE CRIMPING AREA.
6		
7		

D. CONDITIONS

AFTER CRIMPING , THE CRIMPED CONDUCTOR AREA SHOULD BE AS FOLLOWS.

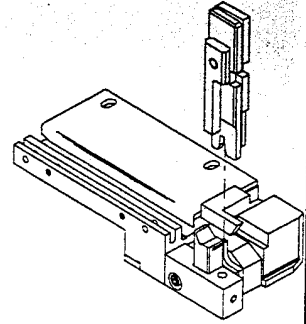
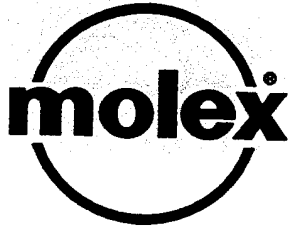
TERMINAL SERIES	WIRE AWG	CRIMP HEIGHT		CRIMP WIDTH (REF.)		PULL FORCE MINIMUM	
		ENGLISH	(METRIC)	ENGLISH	(METRIC)	LBS.	(N)
43178-2001	14	.078 - .082	(1.98 - 2.08)	.126	(3.20)	50	(222)
	16	.074 - .078	(1.88 - 1.98)			30	(133)
	18	.070 - .074	(1.78 - 1.88)			20	(88.9)
	18 DBL	.077 - .081	(1.96 - 2.06)			20	(88.9)
		-	(-)		()		()
		-	(-)		()		()
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		-	(-)		()		()

E. NOTES

1. WE RECOMMEND AN EXTRA SET OF PERISHABLE TOOLING BE MAINTAINED IN YOUR FACTORY.
2. VERIFY TOOLING ALIGNMENT BY MANUALLY CYCLING THE PRESS AND DIE BEFORE CRIMPING UNDERPOWER. CHECK THAT ALL SCREWS ARE TIGHT.
3. SLUGS, TERMINALS, DIRT AND OIL SHOULD BE KEPT CLEAR OF WORK AREA.
4. TO USE THE ABOVE SETTINGS, YOUR PRESS SHOULD HAVE A SHUT HEIGHT OF 135.8 MM. CRIMP HEIGHT MAY STILL VARY DEPENDING ON STYLE AND WIRE TYPE. SHIMMING COULD BE NECESSARY TO ACHIEVE CRIMP HEIGHTS.
5. TO PREVENT INJURY - NEVER OPERATE THIS TOOL WITHOUT THE GUARDING SUPPLIED WITH THE PRESS IN PLACE.

CRIMP

MFG. SII. REV.	Release for Prod. ECN #U96506 12-05-96 KDP	REVISIONS	DIMENSIONS SHOWN (METRIC) INCH		= = REVISE ONLY ON CAD SYSTEM
			UNLESS OTHERWISE SPECIFIED TOLERANCES: ANGULAR = 1/2°		
			INCH	METRIC	TITLE
			3 PLACE ± ---	---	SPECIFICATION SHEET
			2 PLACE ± ---	± ---	TERMINATOR
			1 PLACE ---	± ---	
			DRAFT WHERE APPLICABLE MUST REMAIN WITHIN DIMENSIONS		MOLEX INCORPORATED SHEET NO. DATE LISLE, ILL. 60532 U.S.A. 2 OF 4 96/12/05
			DRWG. BY KDP	CHK'D. BY MFS	PART NO. DRWG. NO.
					638406300 638406300
			APP'D. BY	SCALE	FILE NAME 6384063 S8
					THIS DRAWING CONTAINS INFORMATION THAT IS PROPRIETARY TO MOLEX INC. AND SHOULD NOT BE USED WITHOUT WRITTEN PERMISSION.
					DIV. SIZE AT A



APPLICATOR ASSEMBLY - PARTS LIST

ITEM	ORDER NO.	SIZE	ENG. NO.	DESCRIPTION	REQ'D
4	634430021	b	634430021	Mounting Key	1
5	11-18-5415	b	60842a111	Anvil Mount	1
10	11-40-4039	b	8302-5	Plunger Striker	1
11	638406011	b	638406011	Wire Stop	1
13	11-40-4068	b	8302-102	Drag Finger	1
14	11-40-4231	b	8329-10	Stop Finger	1
15	11-18-5440	b	60842a117	Rear Cover	1
16	11-40-4069	b	8302-103	Pivot Pin	1
17	11-40-4144	b	8302-110	Torsion Spring, Drag Finger	2
18	11-40-4145	b	8302-111	Torsion Spring, Stop Finger	1
19	637000539	b	637000539	HEAVY DUTY CUT-OFF PLUNGER SPRING	1
21	634430009	b	634430009	SCRAP CHUTE	1

TOOLING INFORMATION

ITEM	ORDER NO.	SIZE	ENG. NO.	DESCRIPTION	REQ'D
2	634430012	B	634430012	Front Plunger Retainer	1
3	634430002	B	634430002	Front Cutoff Plunger	1
6	634443217	b	634443217	Conductor Punch	1
7	634453262	b	634453262	Conductor Anvil	1
8	6344648-65	b	6344648-65	Insulation Punch (non-tip)	1
9	634454817	b	634454817	Insulation Anvil	1
10	638406370	/	638406370	Toolkit (above items)	0

Collect THIS (no fee)

FRAME ASSEMBLY PARTS LIST

ITEM	ORDER NO.	SIZE	ENG. NO.	DESCRIPTION	REQ'D
20	638406020	C	638406020	Terminal Track	1

CRIMP

M.F.G. SH. REV. RELEASE FOR PRODUCTION MFS 12-04-96 ECN #U96506	REVISIONS	DIMENSIONS SHOWN (METRIC) INCH		$\nabla =$ $\blacktriangledown =$ REVISE ONLY ON CAD SYSTEM													
		UNLESS OTHERWISE SPECIFIED TOLERANCES: ANGULAR = 1/2°		TITLE													
		<table border="1"> <thead> <tr> <th></th> <th>INCH</th> <th>METRIC</th> </tr> </thead> <tbody> <tr> <td>3 PLACE</td> <td>± ---</td> <td>---</td> </tr> <tr> <td>2 PLACE</td> <td>± ---</td> <td>± ---</td> </tr> <tr> <td>1 PLACE</td> <td>---</td> <td>± ---</td> </tr> </tbody> </table>			INCH	METRIC	3 PLACE	± ---	---	2 PLACE	± ---	± ---	1 PLACE	---	± ---	BILL OF MATERIALS	
			INCH	METRIC													
3 PLACE	± ---	---															
2 PLACE	± ---	± ---															
1 PLACE	---	± ---															
DRAFT WHERE APPLICABLE MUST REMAIN WITHIN DIMENSIONS		TERMINATOR		MOLEX INCORPORATED SHEET NO. DATE LISLE, ILL. 60532 U.S.A. 3 OF 4 2/04/96													
M.F.G.	A	DRWG. BY	MFS	CHK'D. BY	MFS												
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			PART NO.	638406300	DRWG. NO.												
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